

Work Order ID 60622

Thursday, July 15, 2010 10:27:56 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 10-7-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *10575*
Large Fab

0.00

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

10 10.07.22

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Cpl 10.07.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/07/23



Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 10-7-26,

W/O:		WORK ORDER CHANGES						
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Reference:

Run Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

M/14841

1ST COAT:

START TIME: *1:15*

OVEN TEMPERATURE: *1400*

FINISH TIME: *1:45*

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

① Bf 10-7-20

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EP 10/07/27-0

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Reference:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

Pick Kit

EP 07/27 @

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

*8/10/2010**(10)*

170



Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

Memo

0.00

Packaging

*w/o B60621**EP 07/27 @*

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Reference:

Run Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28

u 10-07-27

W/O:		WORK ORDER CHANGES						
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Page 1

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	13.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Mounting Bracket

Location

Loc Qty

Loc Code

WA

13

46086

2

51745

1

57185

1



59265

9

D3913-1

Manufactured No

100

Each

4.0000

1

1



Rib

Location

Loc Qty

Loc Code

WA

4

59337

1

59842

3

D3913-15

Manufactured No

100

Each

6.0000

1

1



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

6

58586

3

60324

3

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Page 2

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3913-3

 Rib

Manufactured No

100 Each

5.0000

1

1

Location

Loc Qty

Loc Code

WA

5

59338

2

60323

3



10.07.15

D3913-7

 Rib

Manufactured No

100 Each

11.0000

2

2

Location

Loc Qty

Loc Code

WA

11

59339

2

* 59743

3

60263

6



10.07.15

D3913-9

 Hinge Rib

Manufactured No

100 Each

5.0000

1

1

Location

Loc Qty

Loc Code

WA

5

59731

2

60322

3



10.07.15

D3916-041

 Rib Assembly

Manufactured No

100 Each

4.0000

2

2

Location

Loc Qty

Loc Code

WA

4

59732

4



10.07.15

Thursday, July 15, 2010 10:28:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Page 3

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3916-5
Light Rib

Manufactured No 100 Each 9.0000 3 3

Location	Loc Qty	Loc Code
WA	9	
57023	2	
59535	7	

PD 10.07.15

D4016-1
Hinge Half, Base

Manufactured No 100 Each 9.0000 3 3

Location	Loc Qty	Loc Code
WA	9	
59983	9	

PD 10.07.15

D4017-7
Rib

Manufactured No 100 Each 8.0000 1 1

Location	Loc Qty	Loc Code
WA	8	
58929	2	
59836	3	
60473	3	

PD 10.07.15

D4017-9
Rib

Manufactured No 100 Each 10.0000 2 2

Location	Loc Qty	Loc Code
WA	10	
59538	4	
59984	6	

PD 10.07.15

Thursday, July 15, 2010 10:28:01 AM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 60622

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4020-1 Manufactured No

100 Each

4.0000

1

1



Mesh (350 Basket Long, Base)

Location

Loc Qty

Loc Code

WA

4

59555

1

59848

3



PD 10.07.21

D4020-11 Manufactured No

100 Each

10.0000

2

2



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

10

58136

1

59413

5

59942

4



PD 10.07.22

D4021-1 Manufactured No

100 Each

18.0000

3

3



Handle Plate

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

13

59746

4

60183

9



PD 10.07.15

D4034-041 Manufactured No

100 Each

3.0000

1

1



Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

3

58729

1

59747

2



PD 10.07.15

Thursday, July 15, 2010 10:28:01 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4034-043 Manufactured No

100 Each

3.0000

1 1



Fwd Upper Rib Assembly



PD 10.07.15

Location

Loc Qty

Loc Code

WA

3

59748

3

AN3-10A Purchased No

150 Each

85.0000

6 6



Bolt



EP 10/07/27

Location

Loc Qty

Loc Code

ST351

85

115016

85

AN960JD8 NAS1149DN832 Purchased No

150 Each

0.0000

2 2



Washer

D2931

Manufactured No

150 Each

816.0000

2 2



Bumper



EP 10/07/27

Location

Loc Qty

Loc Code

ST504

816

46064

816

D4021-5 Manufactured No

150 Each

3.0000

2 2



Blanking Plate



EP 10/07/27

Location

Loc Qty

Loc Code

ST111

3

59096

3

360717 (24)

Thursday, July 15, 2010 10:28:01 AM

Shop Packet Print

Page 5

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Page 6

Work Order ID: 60622

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3 Purchased No

150 Each

1,631.000

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1631

106375

3

107939

822

111636

806



2
E 8/0/07/27

MS21042L3 Purchased No

150 Each

2,684.000

6



Nut

Location

Loc Qty

Loc Code

ST300

2684

112385

4

114523

204

114718

476

114784

2000



6
E 8/0/07/27

NAS1149F0332P Purchased No

150 Each

691.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

691

18057

691



12
E 8/0/07/27

Thursday, July 15, 2010 10:28:01 AM

Shop Packet Print

Page 6

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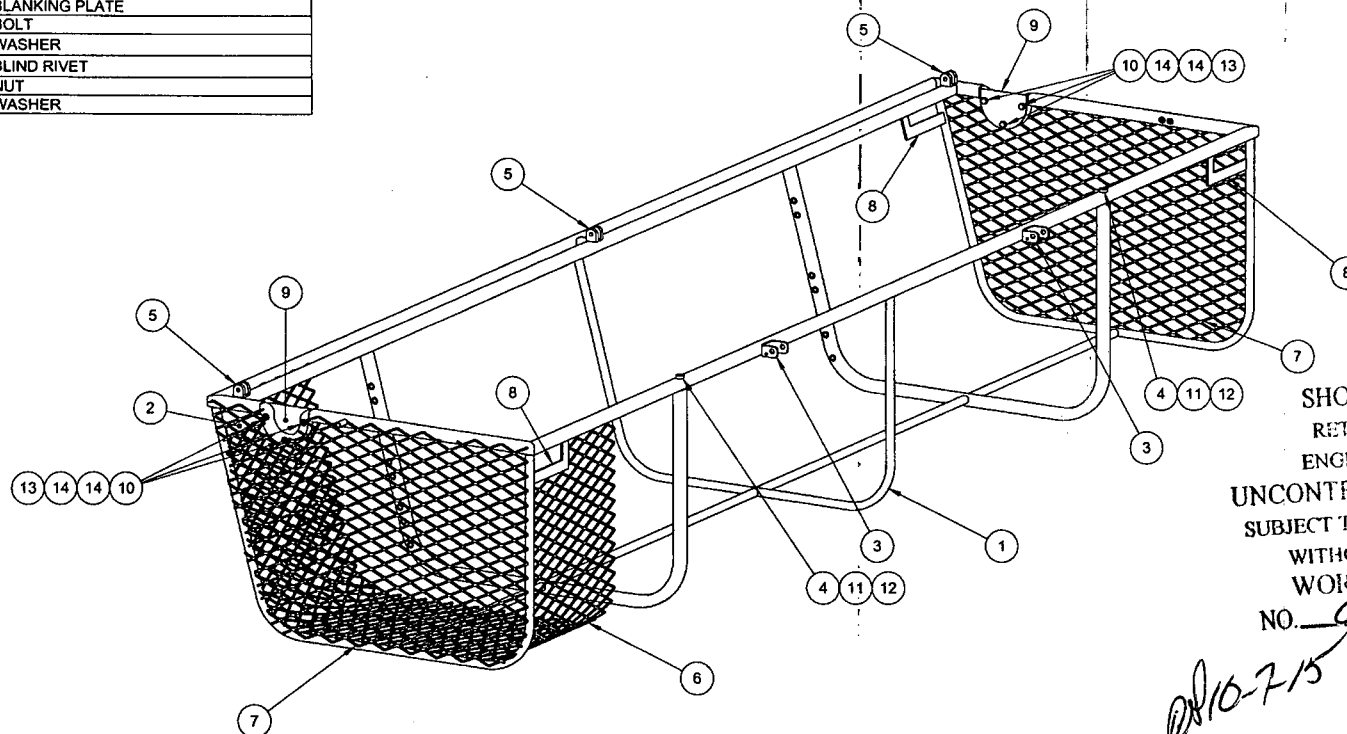
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 60622

RELEASED
2010-03-22
WJP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3913	SHEET 1 OF 6
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

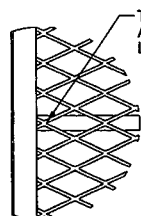
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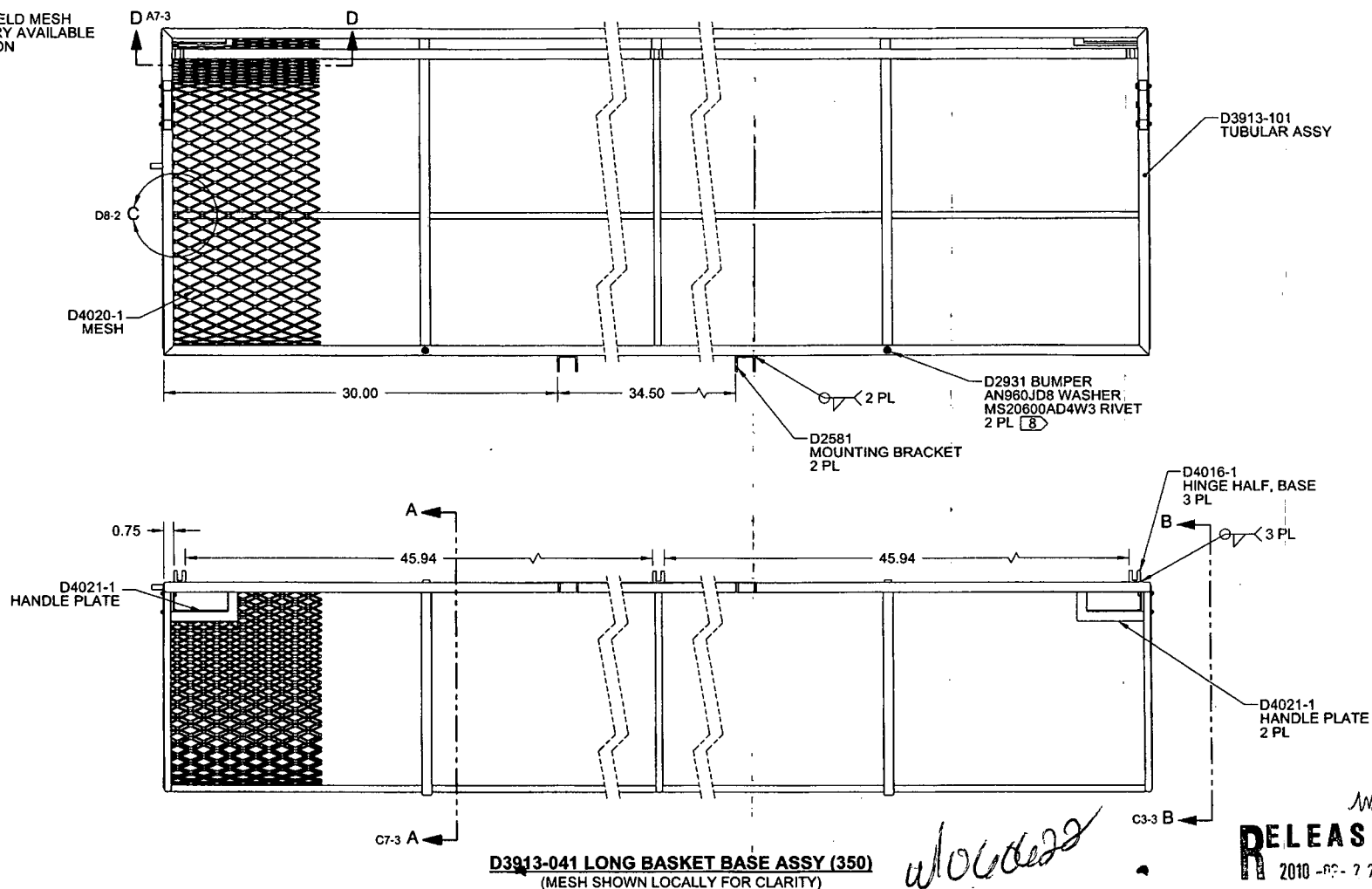
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DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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2010-07-27

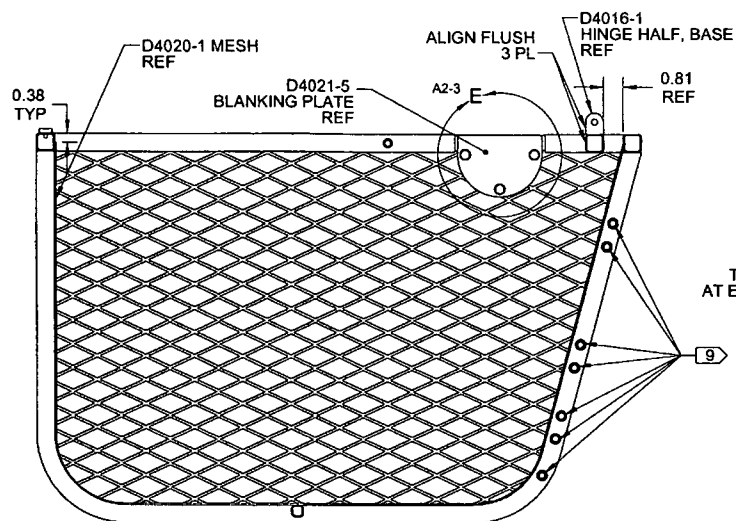
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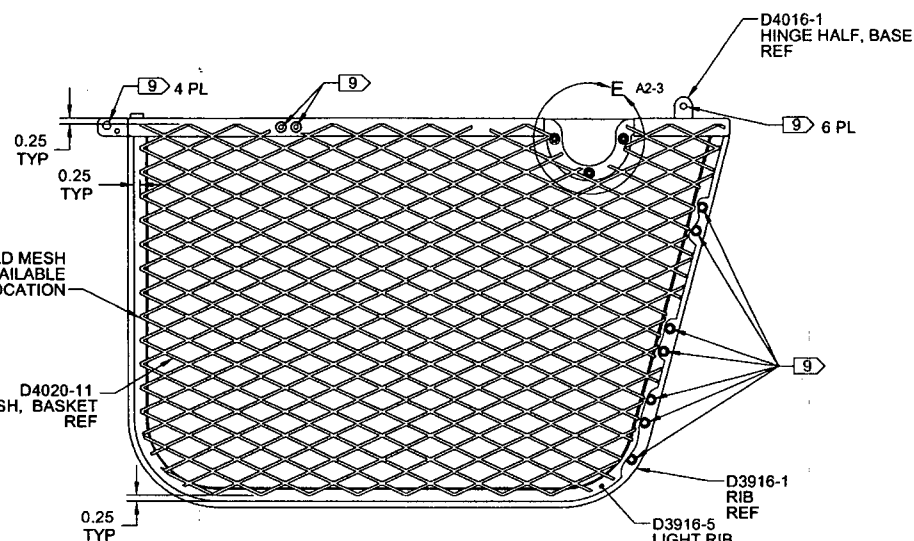
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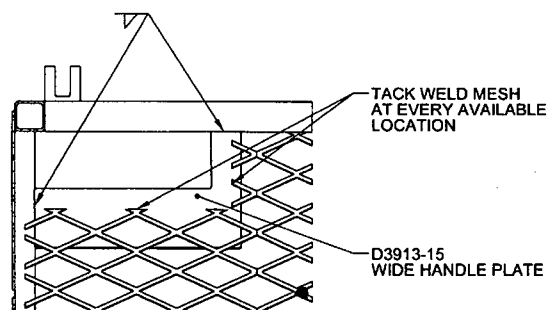
NOTE: Date & initial all entries



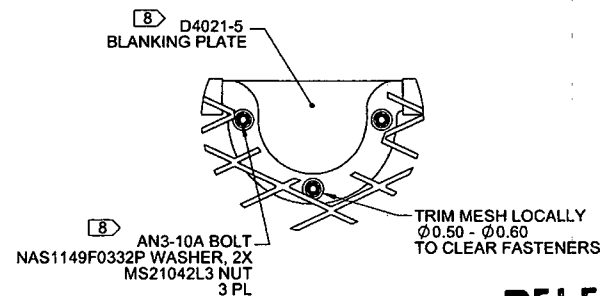
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

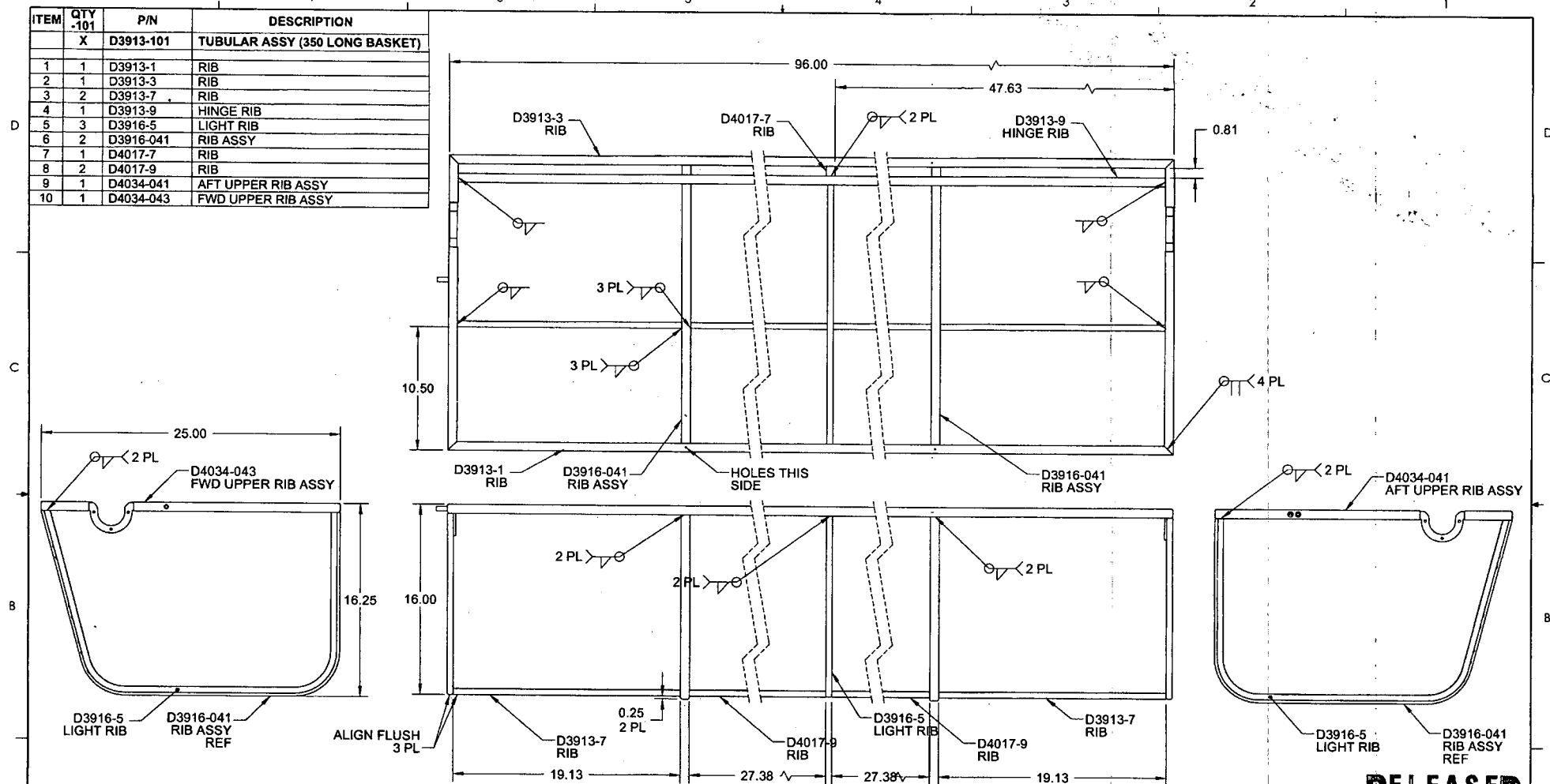
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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CHECKED		DRAWING NO.	REV. A
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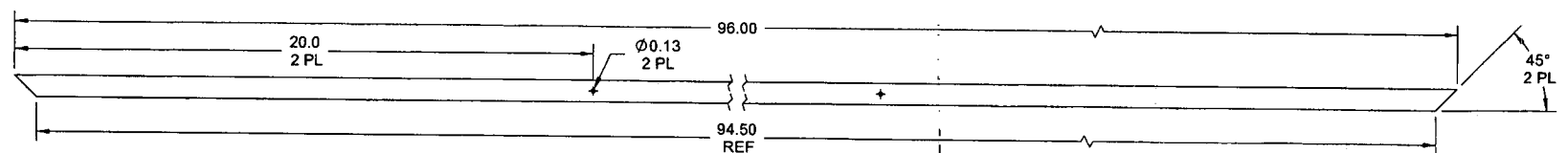
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

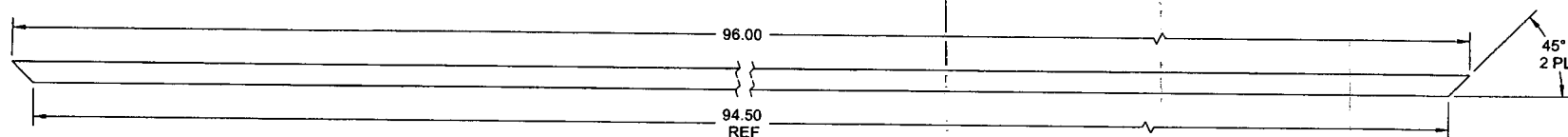
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

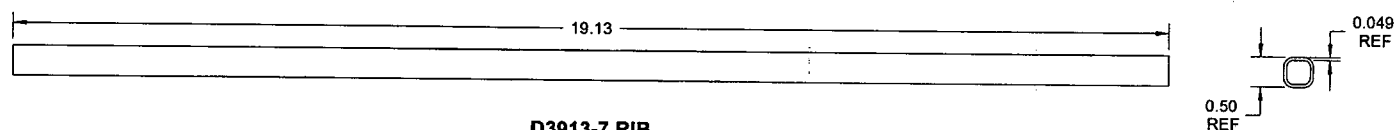
NOTE: Date & initial all entries



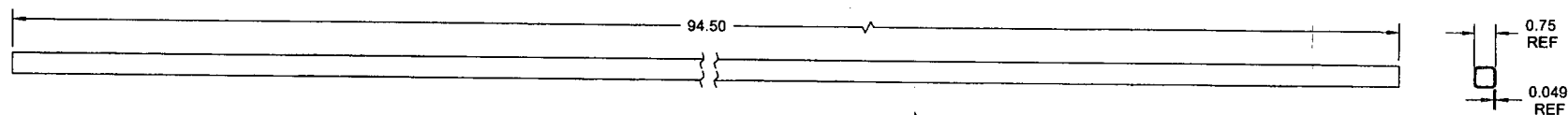
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.		D3913	SHEET 5 OF 6
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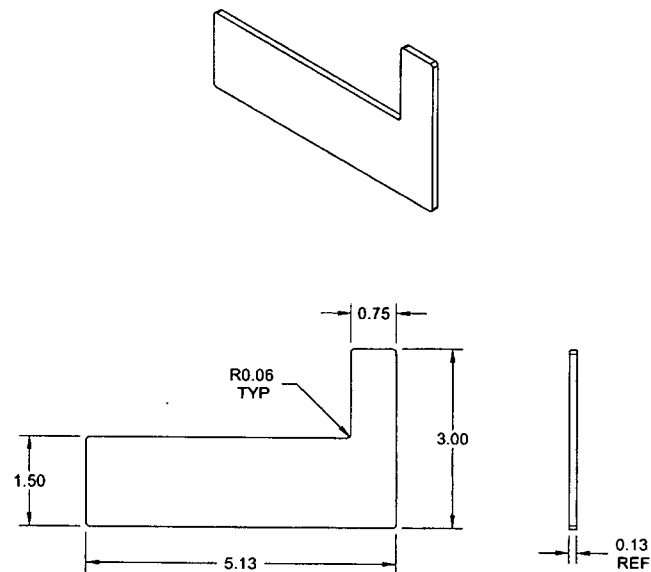
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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w/b 60622

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries